

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-196 **Date Opened:** 17 Nov. 17 **Title:** Assembly**Aircraft OEM:** Bell **Aircraft Model:** 407 **Product Type:** Cargo Basket **Product Model:** High Ski **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76610	1	Basket	CB/JC
76627	1	Placard	CB/JC
70405	4	Lid Walkway	CB/JC
84255	2	Handle Installation	CB/JC
84240	0	Lid Brace Installation	CB/JC

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

CB/JR
CB/JR
JR
JR
JR
JR
CB/JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: C. Brander J RekveSign: SCA: AD01Date: 22-Nov-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 22-Nov-17

Work Order closed by:

Print: C. Brander J. ClarkeSign: SCA: AD02Date: 23-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Aerospace Bandy Machining

Color:

N/A

WO#:

N/A

PO# 17017



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: All

Model: All

Description: Hinge

Supplier: GKN Aerospace Bandy Machining

Color: N/A

WO#: N/A

PO# 17017



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC

V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Aerospace Bandy Machining

Color:

N/A

WO#:

N/A

PO# 17017



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle Bar Assy No. of pieces: 1

Manufacturer: Aero Design

Part No.: 84261-01 Serial/Batch No.: NSN

TTSN: N/P TSO: N/A Rem.: N/A

Work Order No.: 2017-194

Remaining Tasks to be Performed: To be installed

Signature: [Signature] AD

Date: Nov 21/2017 Lic. No. / SCA 73-04
05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Tread Plate

Aircraft:

All

Model: N/A

Description:

Lid Walkway Checker Plate

Supplier:

Ryerson

Color:

Aluminum

WO#:

N/A

PO# 17081



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Lid No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76612-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-06

Remaining Tasks to be Performed: Clean up, Inspect,
Powder coat.

Signature: David Marty

Date: Nov 3/2017

Lic. No. / SCA 730405

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 H.M. Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76611-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

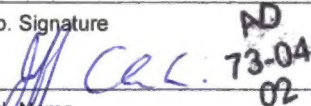
Work Order No.: 2017-163-06

Remaining Tasks to be Performed: Clean up, Inspect,
Powder coat. ✓ ✓

Signature: *David Marty*

Date: Nov 14/2017 Lic. No. / SCA AD 73-04 05

In Process

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0424
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-196
6. Item 1.	7. Description Cargo Basket Ass'y	8. Part Number 76610-01	9. Qty. 1	10. Serial/Batch No. 76601-29	11. Status/Work New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 22 Nov 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

ALPINE HELICOPTERS

CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-196

Date Open: 17 Nov. 2017

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

✓	Basket Type	Basket			Lid Walk	Lid Prop	Handle		
		Ass'y	Placard	Mat'l			Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	80210	80227	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	80310	80327	Mat'l					Mat'l
	Long	81110	81127	Mat'l					Mat'l
Bell 206L/407 – Right side only									
	Low Standard	69810	69827	Mat'l	70405	84240	84255	84261	Mat'l
	Low Wide	94510	94527	Mat'l					Mat'l
	Low Ski	94610	94627	Mat'l					Mat'l
	High Ski	76610	76625	Mat'l					Mat'l
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	84240	84255	84261	Mat'l
	Extra Large (ski)	95510	95527	Mat'l					Mat'l
	Mega	100610	100627	Mat'l					Mat'l
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	84240	84255	84261	Mat'l
	Standard – Post S/N 71	95950	95927	Mat'l					Mat'l
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	76410	76427	Mat'l					Mat'l
	Long	78410	78427	Mat'l					Mat'l
	Ski	94010	94027	Mat'l					Mat'l
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	70405	84240	84255	84261	Mat'l
MD600									
	Standard	82810	82827	Mat'l	70405	84240	84255	84261	Mat'l

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

CB

1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body. N/A

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length. OK
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink. OK
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket N/A
- i. Locate sheet on basket.
 - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet N/A
- i. Locate sheet on basket. Ensure sufficient clamps are in place.
 - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation CB

- a. Prepare hinge.
- i. Cut hinge to length:
 1. 776, 906 – 54"
 2. 751, 803 – 70"
 3. 698, 764, 945 – 72"
 4. 766, 784 – 90"
 5. 940, 946, 959 – 95"
 6. 1006 – 107"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
- i. Locate hinge on basket (standard baskets)
 1. centre fore/aft
 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 1. centre fore/aft
 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 2. CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places. *OK*
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly. *OK*
 - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in. *OK*
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

OK

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

N/AAD
73-04
02

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2017-199

Date Opened: 17 Nov 2017

Material Tracking Sheet
Bell 206L / 407
HIGH Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		76610-01	Cargo Basket Assembly		S/N 76601-29
Step 1				<i>Lid Assembly</i>		
	. 1		76612-01	Basket Lid Assembly		<i>2017-163-06</i>
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	<i>See PDS</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	<i>N/A</i>
Step 1.b.	. . 1		76627-01	Placard	0.050 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	. . 4		CR3213-4-02	Cherry Rivet		<i>17070</i>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>17081</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>17070</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	<i>N/A</i>
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		76611-01	Basket Body Assembly		<i>2017-163-06</i>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<i>See PDS</i>
	. . 8		NAS1149F0663P	Washer		<i>See PDS</i>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	90"	<i>17017</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>16063</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>16053</i>
Step 4	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2017-150</i>
	. . 4		AN3-11A	Bolt		<i>See PDS</i>
	. . 8		NAS1149F0363P	Washer		<i>See PDS</i>
	. . 4		MS21044N3	Nut		<i>See PDS</i>

17 Nov 17
rev 1

Work Order: _____

Material Tracking Sheet

2 of 2

Bell 206L / 407

• Date Opened: _____

HIGH Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-194
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		84280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	

17 Nov 17
rev 1



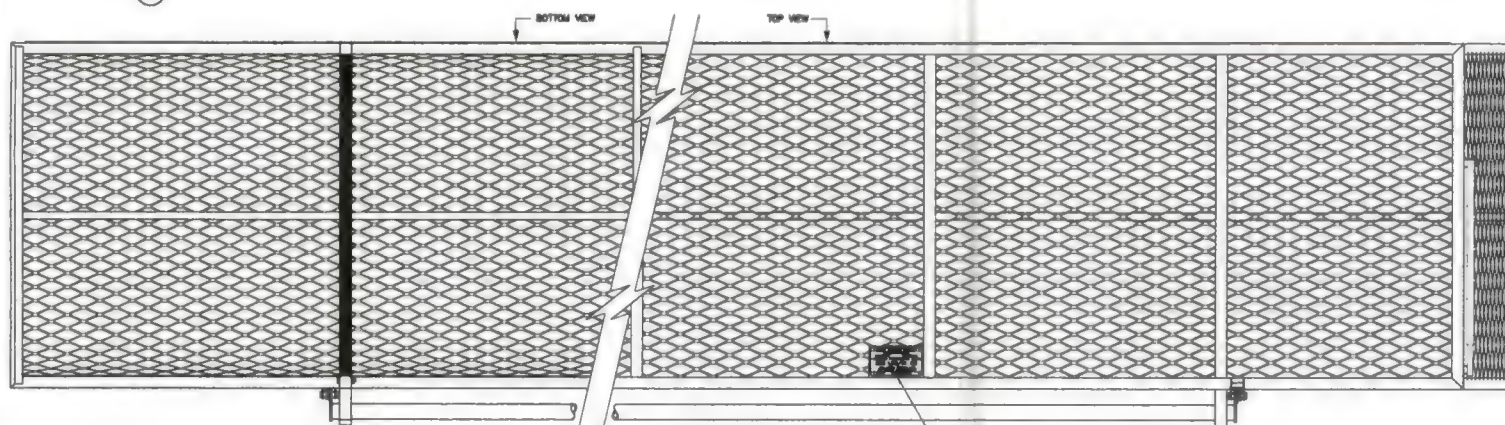
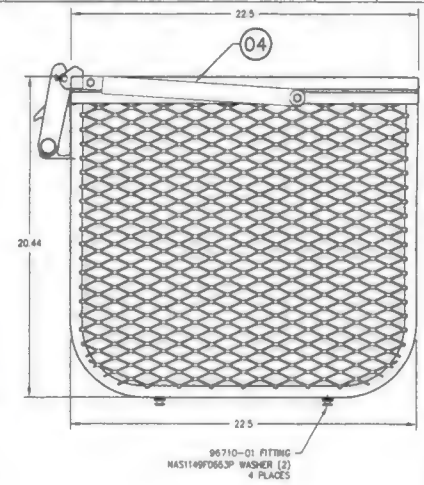
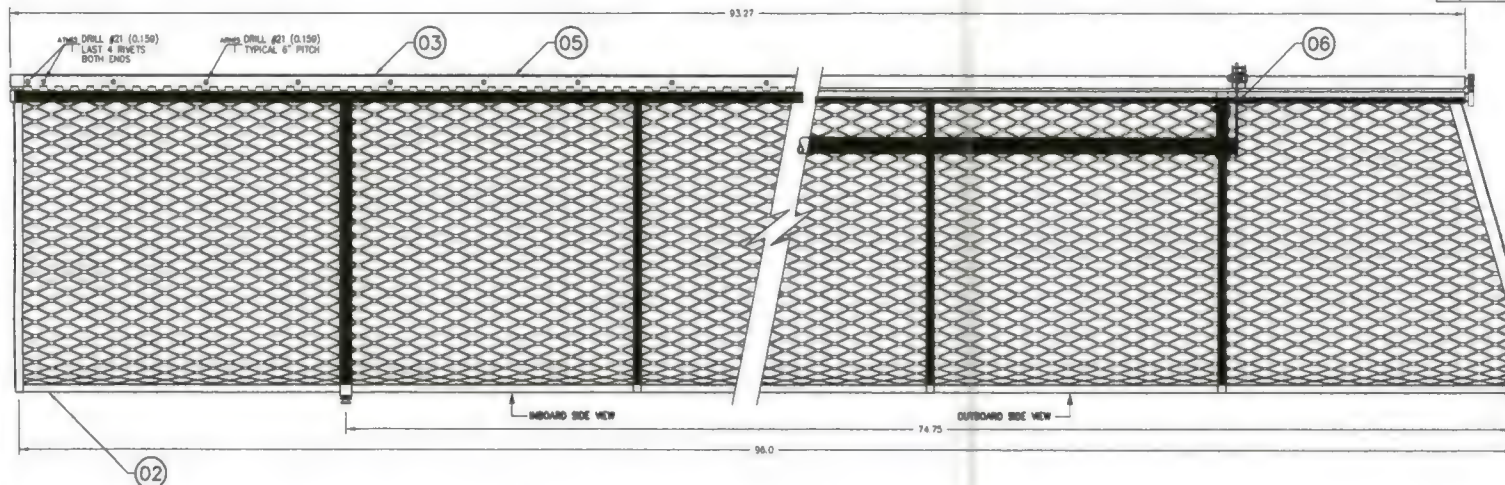
Description: Basket Assembly Kit

WO# 2017-199 196 CB

AR-2017-126

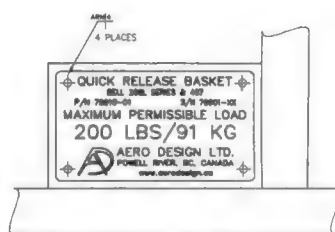
2017-196

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM EGG30	BUC	25/09/2007
1	TITLE BLOCK UPDATED, HANDLE UPDATED TO B42 CONFIGURATION	BUC	25/09/2007
2	PLACARD UPDATED AND MOVED TO OPPOSITE SIDE, HARDWARE UPDATED		
	ATTACHMENT HOOPS UPDATED		



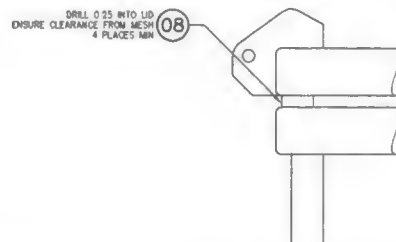
NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

01 CARGO BASKET ASSEMBLY



DETAIL B

SCALE 1:1
LOOKING AT PLACARD BRACKET



BUMPER INSTALLATION

SCALE 1:1

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL
4	CR3213-4-02		CHERRY RIVET	ALT HR3213-4-02
8	CR3523-5-02		CHERRY RIVET	ALT HR3523-5-02
A/R	CR3213-5-02		CHERRY RIVET	ALT HR3213-5-02
1	WASHER		WASHER	
4	96710-01		FITTING	ALT ANORA 4008B-14
4	49205-14	08	BUMPER	ARGUS INDUSTRIES
1	76627-01	07	PLACARD	
1	84255-01	06	HANDLE BAR INSTALLATION	
1	M52000PA	05	PIANO HINGE	90 INCHES
1	84240-01	04	BRACE INSTALLATION	
1	60632-01	03	LID ASSEMBLY	
1	76611-01	02	BASKET BODY ASSEMBLY	
1	76610-01	01	CARGO BASKET ASSEMBLY	

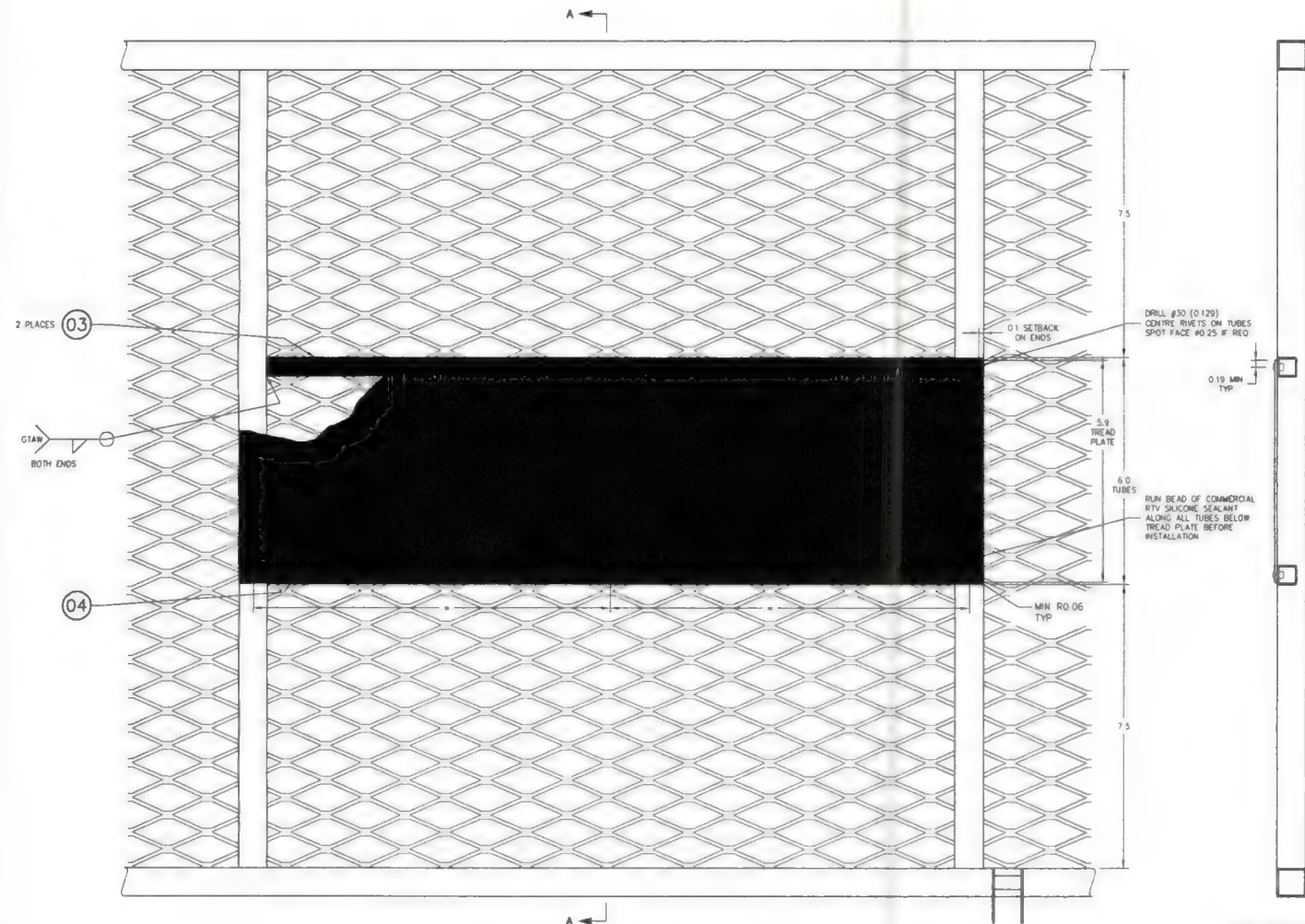
LIST OF MATERIALS

BASIC CODE	DASH NO FOR DIAMETER	APPROVALS	DATE
REF. HAS 323	N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE	DRAWN: JEFF CLARKE	25 SEPT 2007
C=COUNTERSUNK D=DIMPLE DIGIT=g OF SHEETS TO BE DIMPLED	DASH NO FOR LENGTH	CHECKED: E. BURGON	27 SEPT 2007
BASIC CODES: BU=M520470AD BB=M520426AD ARH=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES X.XXX ±0.010 X.X ±0.03 X.X ±0.1	



AERO DESIGN LTD.
9088A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8B 0G3
TEL: 604.483.2378 www.aerodesign.ca

BELL 407, 206L SERIES QUICK RELEASE HIGH MOUNTED CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE	SHEET	REV	REV
1:1	1 OF 1	A1	1



(01) BASKET LID ASSEMBLY

SECTION A-A

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR NOTATION, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCCONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BJC	28/05/2014

NOTES

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02	
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND N	MIL.-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY			
01	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP			
	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
	QTY				STOCK SIZE

BASIC CODE		DASH NO. FOR DIAMETER		APPROVALS		DATE	
REF: HAS 523		N=MFD HEAD NEAR SIDE		DRAWN: JEFF CLARKE	21 SEPT 2006		
C=COUNTERSUNK		F=MFD HEAD FAR SIDE		CHECKED: E. BURGOIN			
D=DIMPLE				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			
DIGIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		DECIMALS ANGLES X XXX ±0.010 ±1/2" X XX ±0.03 X X ±0.1			
BASIC CODES:				+ □ INSTALL NEW RIVET + □ REMOVE/REPLACE RIVET - □ EXISTING RIVET			
BJ=MS20470AD				SCALE: 1:15 SHEET 1 OF 1			
BB=MS20426AD				DWG. SIZE: A1 DWG. NO.: 70405			
ARM=CR3213				REV: 4			
ARM=CR3212				CARGO BASKET LID STEP MODIFICATION			



AERO DESIGN LTD.

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POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804 483 3376 www.aerodesign.co

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - 76625		
1	DWG # CHANGED TO 76627; UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO	BJC	09/08/2016
	MAT'L THICKNESS CHANGED; P/N ADDED		

NOTES


1. ENGRAVE 0.007 DEEP AS FOLLOWS:

- "QUICK RELEASE BASKET" - 0.125 HIGH
- "BELL 206L SERIES & 407" - 0.080 HIGH
- "P/N 76610-01 S/N 76601-XX" - 0.080 HIGH
- "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
- "200 LBS. TOTAL" - 0.200 HIGH
- "AERO DESIGN LTD." - 0.125 HIGH
- "POWELL RIVER, BC, CANADA" - 0.080 HIGH
- "www.aerodesign.ca" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES

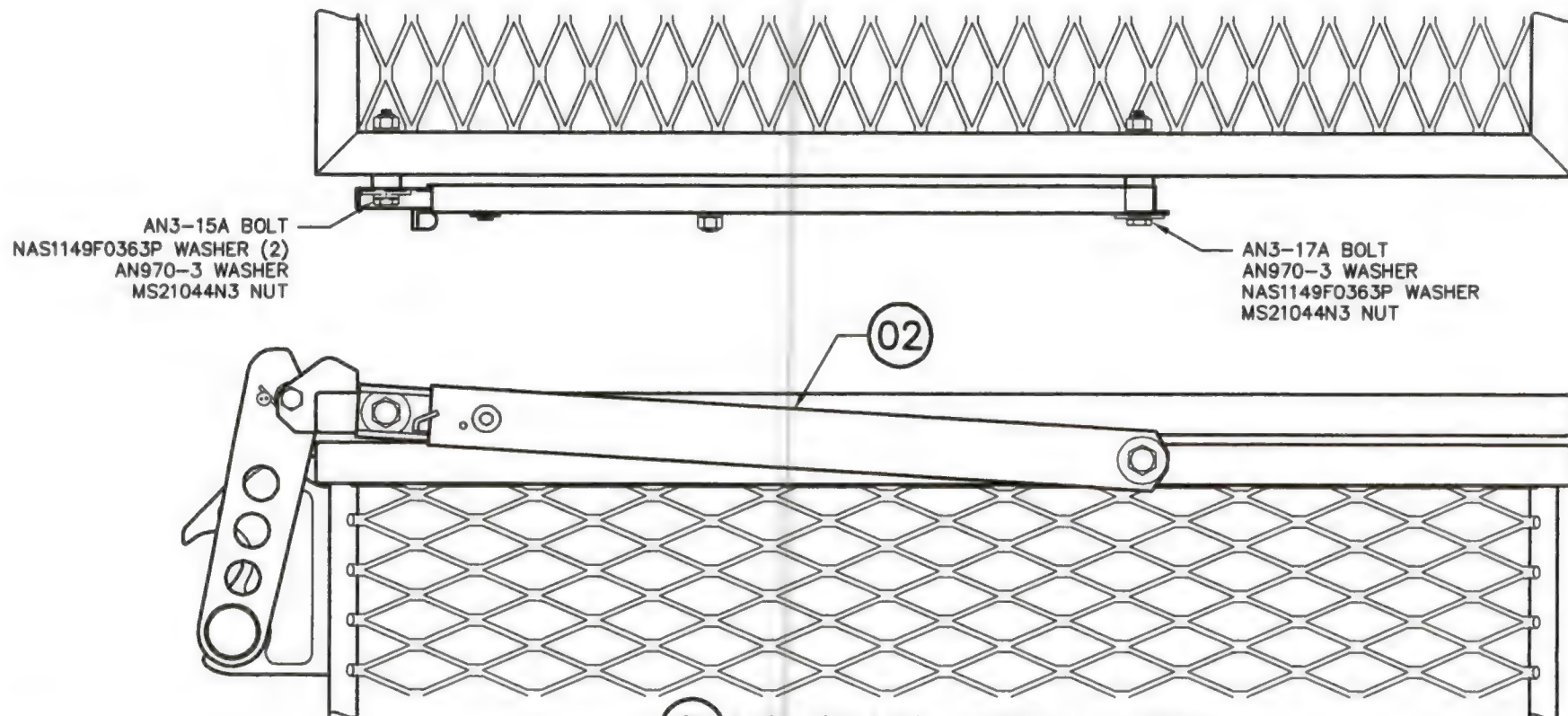


01 PLACARD

1	76627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.05 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
<div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.</div>			APPROVALS		DATE	
			DRAWN: JEFF CLARKE		09 AUG 2016	
			CHECKED: JASON REKVE		09 AUG 2016	
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		<div><div><div>AERO DESIGN LTD.</div><div>9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca</div></div></div>	
			DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			
BELL 206L SERIES AND 407 QUICK RELEASE HIGH MOUNTED CARGO BASKET PLACARD						
SCALE 1 : 1			DWG. SIZE		DWG. NO.	REV.
SHEET 1 OF 1			A1		76627	1

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



AERO DESIGN LTD.

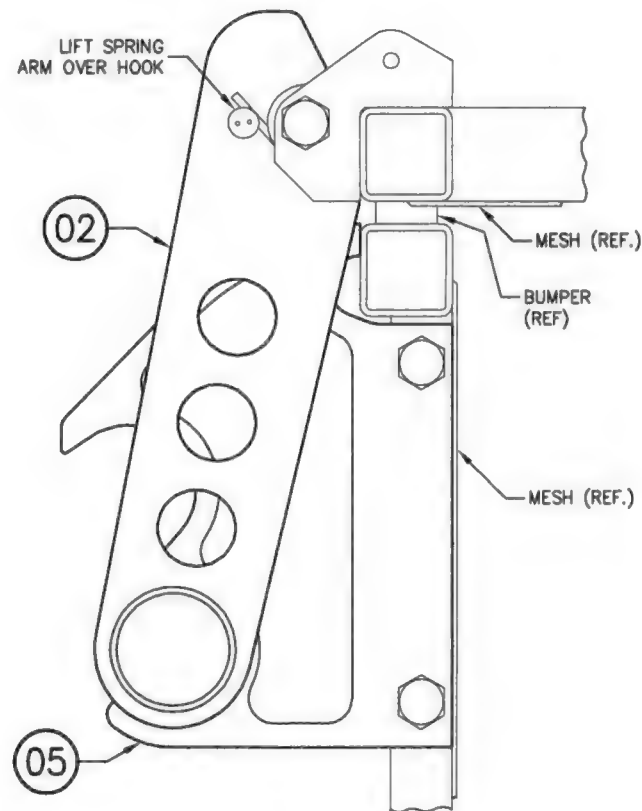
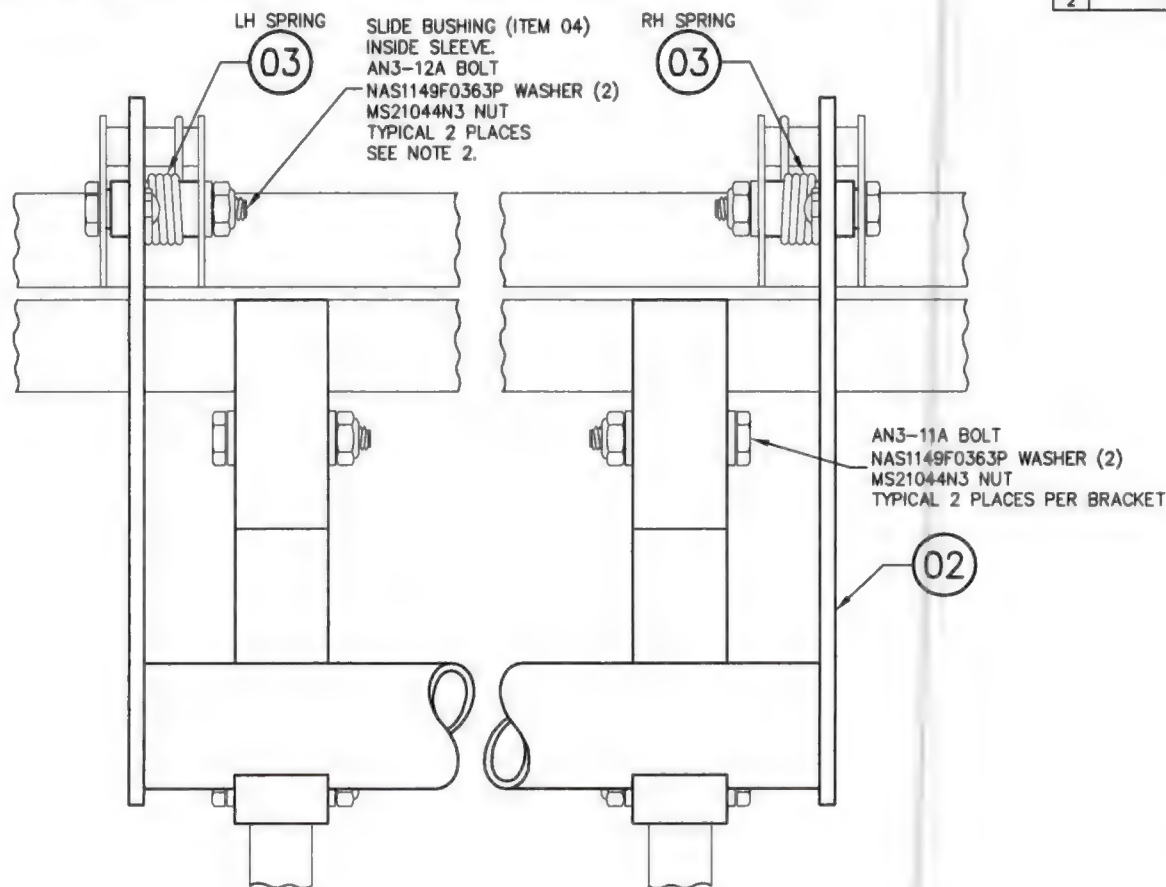
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**HELICOPTER CARGO BASKET
ALL MODELS
LID BRACE INSTALLATION**

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
QTY.	PART NO.	ITEM	DESCRIPTION	MATERIAL
LIST OF MATERIALS				

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



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HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2017-195 **Date Opened:** 17 Nov. 17 **Title:** Assembly**Aircraft OEM:** Bell **Aircraft Model:** 407 **Product Type:** Cargo Basket **Product Model:** High Ski **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76610	1	Basket	CB/JC
76627	1	Placard	CB/JC
70405	4	Lid Walkway	CB/JC
84255	2	Handle Installation	CB/JC
84240	0	Lid Brace Installation	CB/JC

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

CB/JR
CB/JR
JR
JR
JR
JR
CB/JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: C. Brander J Rekke

Sign:



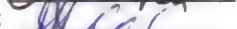
SCA: AD01

Date: 22-Nov-17

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign:



SCA: AD02

Date: 22-Nov-17

Work Order closed by:

Print: C. Brander J. Clarke

Sign:



SCA: AD02

Date: 23-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 H.M. Body No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 76611-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-07

Remaining Tasks to be Performed: Clean up, inspect,
powder coat.

Signature: David Dwyer

Date: Nov 15 / 2017 Lic. No. / SCA AD 0606

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Lid No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76612-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-07

Remaining Tasks to be Performed: Clean up, Inspect,
Powder coat. ✓ ✓

Signature: [Signature]

Date: Nov 3/2017 Lic. No. / SCA 10 15-04 05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle Bar Assy No. of pieces: 1

Manufacturer: Aero Design

Part No.: ~~811~~ 84261 - 01 Serial/Batch No.: NSN

TTSN: N/P TSO: N/A Rem.: N/A

Work Order No.: 2017 - 194

Remaining Tasks to be Performed: To be installed

Signature: *David Phant*

Date: Nov 21 / 2017 Lic. No. / SCA AD 73-04 05

Serviceable



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Tread Plate

Aircraft:

All

Model: N/A

Description:

Lid Walkway Checker Plate

Supplier:

Ryerson

Color:

Aluminum

WO#:

N/A

PO# 17081

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0423
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-195
6. Item 1.	7. Description Cargo Basket Ass'y	8. Part Number 76610-01	9. Qty. 1	10. Serial/Batch No. 76601-28	11. Status/Work New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 22 Nov 2017		14c. Approved Organization Number	
14d. Name		14e. Date (dd/mmm/yyyy)		14f. Signature	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

ALPINE HELICOPTERS

CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-195

Date Open: 17 Nov. 2017

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid	Lid	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l	Walk	Prop	Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	80210	80227	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	80310	80327	Mat'l					Mat'l
	Long	81110	81127	Mat'l					Mat'l
Bell 206L/407 – Right side only									
	Low Standard	69810	69827	Mat'l	70405	84240	84255	84261	Mat'l
	Low Wide	94510	94527	Mat'l					Mat'l
	Low Ski	94610	94627	Mat'l					Mat'l
	High Ski	76610	76625	Mat'l					Mat'l
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	84240	84255	84261	Mat'l
	Extra Large (ski)	95510	95527	Mat'l					Mat'l
	Mega	100610	100627	Mat'l					Mat'l
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	84240	84255	84261	Mat'l
	Standard – Post S/N 71	95950	95927	Mat'l					Mat'l
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	76410	76427	Mat'l					Mat'l
	Long	78410	78427	Mat'l					Mat'l
	Ski	94010	94027	Mat'l					Mat'l
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	70405	84240	84255	84261	Mat'l
MD600									
	Standard	82810	82827	Mat'l	70405	84240	84255	84261	Mat'l

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

dk CB

1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
- Locate sheet on basket. *N/A*
 - Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
 - Remove sheet and de-burr holes in sheet and rim.
 - Apply bead of RTV silicone sealant along all tubes under sheet.
 - Locate sheet on basket, and cleco in place.
 - Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
- Locate sheet on basket. Ensure sufficient clamps are in place. *N/A*
 - Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
 - Remove sheet and de-burr holes in sheet and rim.
 - Apply bead of Pro-Seal sealant along all tubes under sheet.
 - Locate sheet on basket, and cleco in place.
 - Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.
3. Hinge Installation *df CB*
- a. Prepare hinge.
- Cut hinge to length:
 - 776, 906 – 54"
 - 751, 803 – 70"
 - 698, 764, 945 – 72"
 - 766, 784 – 90"
 - 940, 946, 959 – 95"
 - 1006 – 107"
 - Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
- Locate hinge on basket (standard baskets)
 - centre fore/aft
 - 0.15" – 0.18" up from bottom edge
 - Locate hinge on basket (extra wide baskets)
 - centre fore/aft
 - set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - Remove hinge and de-burr holes in hinge and basket rim.
 - Cleco hinge to basket with 5/32 clecos.
 - Install hinge with CherryMax rivets
 - CR3523-5-02 monel rivets – last 2 rivets in each end
 - CR3213-5-02 aluminum rivets – all other locations

c. Install lid on basket

- i. Locate lid on hinge (all baskets)
 1. center fore/aft
 2. 0.15" – 0.18" down from top edge
- ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
- iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
- iv. Remove hinge and de-burr holes in hinge and lid rim.
- v. Cleco lid to hinge with 5/32 clecos.
- vi. Install hinge with CherryMax rivets
 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 2. CR3213-5-02 aluminum rivets – all other locations

d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to 20-25 in-lbs.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to 20-25 in-lbs.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2017-200

Date Opened: 17 Nov. 2017

Material Tracking Sheet

Bell 206L / 407

HIGH Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		76610-01	Cargo Basket Assembly		SN 76601-28
Step 1				<i>Lid Assembly</i>		
	1		76612-01	Basket Lid Assembly		2017-163-07
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	See PDS
	A/R		--	Sealant	Commercial Silicone RTV sealant	N/A
Step 1.b.	1		76627-01	Placard	0.050 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		17070
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17081
	A/R		CR3213-4-02	Cherry Rivet		17070
	A/R		--	Sealant	Commercial Silicone RTV sealant	N/A
Step 2				<i>Basket Assembly</i>		
Step 2.a.	1		76611-01	Basket Body Assembly		2017-163-07
	4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	8		NAS1149F0663P	Washer		See PDS
Step 3				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	17017
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
Step 4	1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		See PDS
	8		NAS1149F0363P	Washer		See PDS
	4		MS21044N3	Nut		See PDS

17 Nov 17
rev 1

Work Order: _____

Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: _____

HIGH Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-194
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		84280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
Step 6	. 2		MS21044N3	Nut		See PDS
				Inspection	None	

17 Nov 17
rev 1

Aero Design

Parts Distribution Sheet

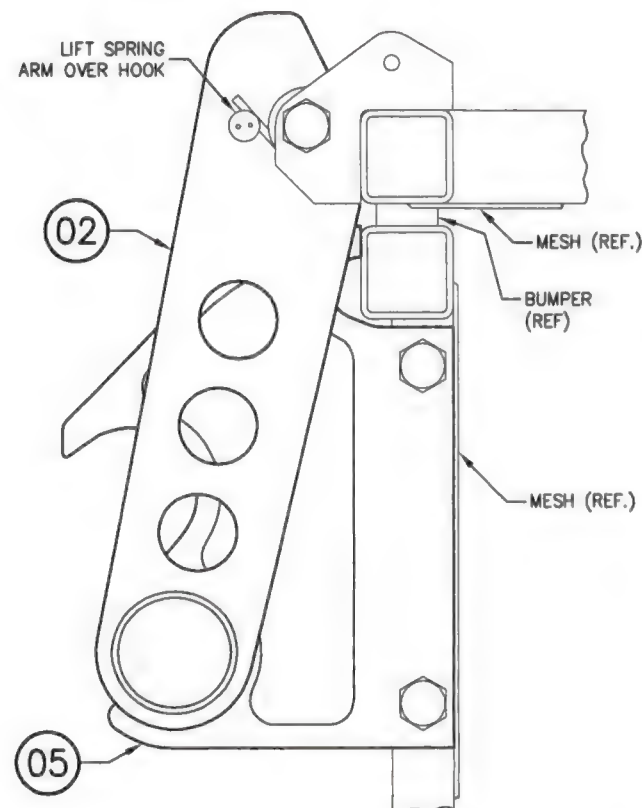
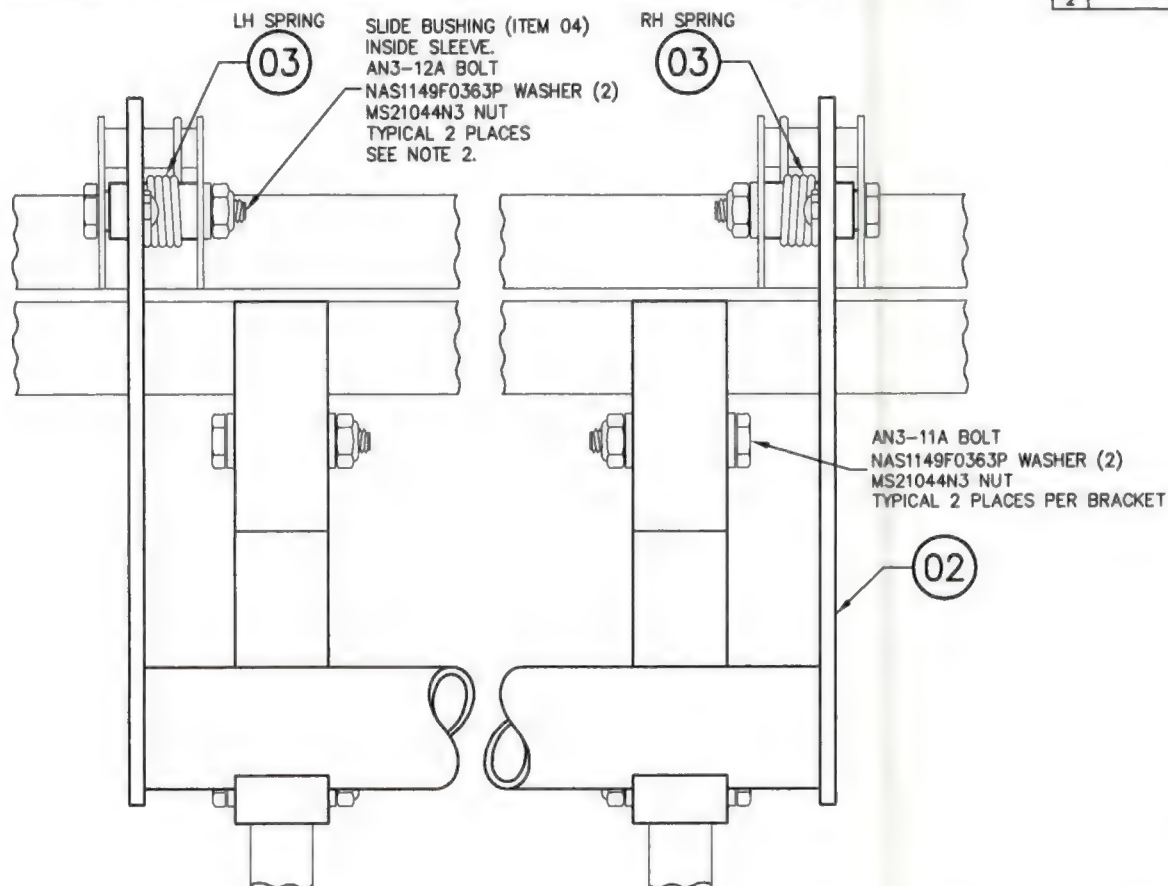
Description: Basket Assembly Kit

WO# 2017-200 195 CR

[illegible]

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE		MIL-PRF-81322F
4	AN3-11A		BOLT		
2	AN3-12A		BOLT		
10	NAS1149F0363P		WASHER		
6	MS21044N3		NUT		
2	84267-01	05	BRACKET		
2	36275-01	04	BUSHING		
2	36278-01	03	SPRING (1 LH, 1 RH)		
1	84261-01	02	HANDLE BAR ASSEMBLY		
	84255-01	01	HANDLE INSTALLATION		
01	PART NO.	ITEM	DESCRIPTION		MATERIAL
QTY.			LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

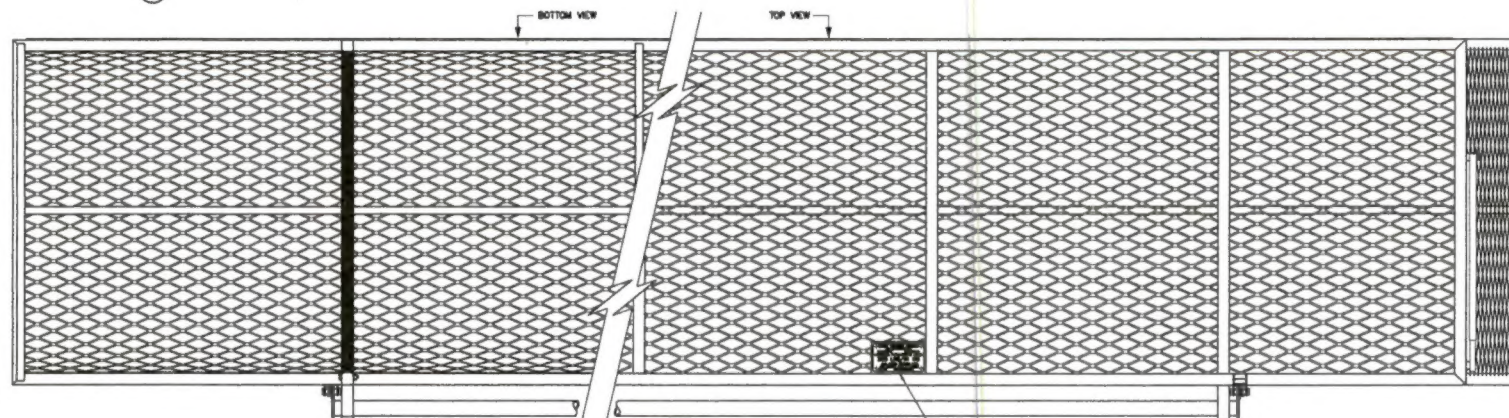
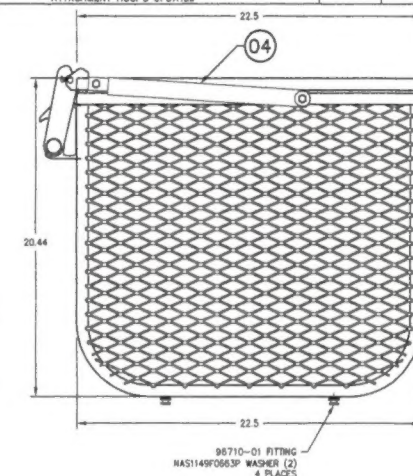
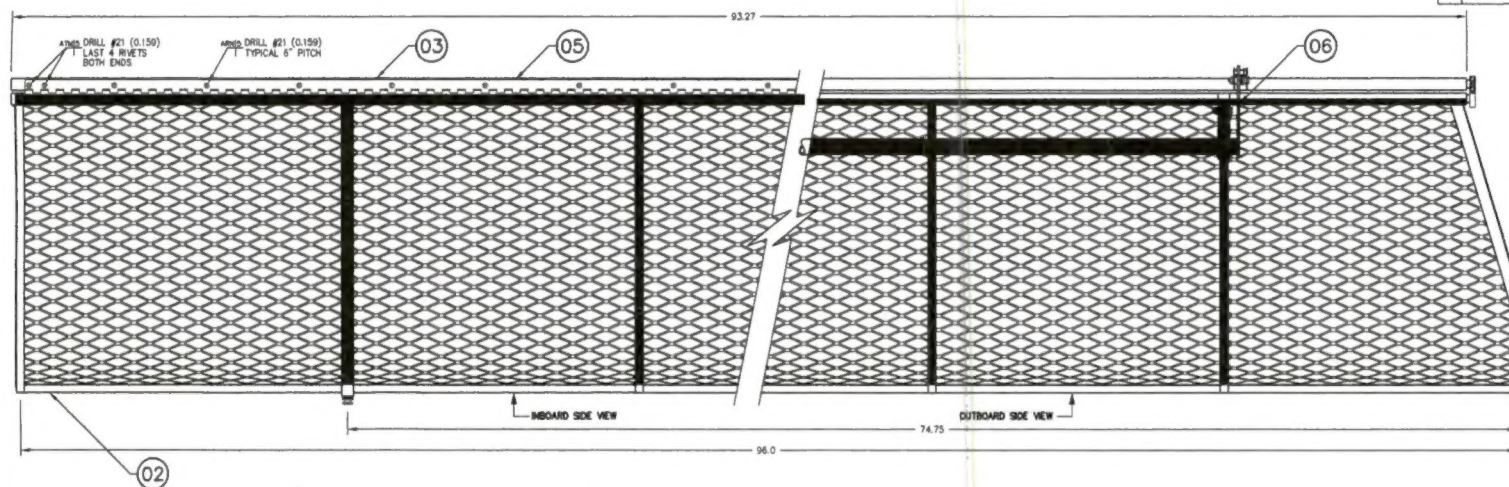
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD.			
9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.2378 www.aerodesign.ca			
HELICOPTER CARGO BASKET HANDLE BAR INSTALLATION			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

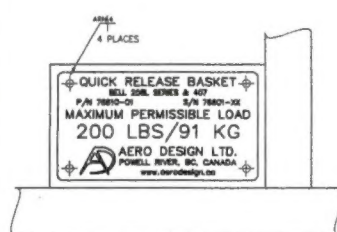
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

2017-195

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 60630	BJC	25/09/2007
1	TITLE BLOCK UPDATED; HANDLE UPDATED TO 842 CONFIGURATION	BJC	25/08/2017
	PLACARD UPDATED AND MOVED TO OPPOSITE SIDE; HARDWARE UPDATED		
	ATTACHMENT HOOPS UPDATED		

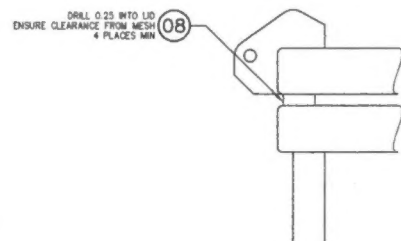


NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



DETAIL B

SCALE 1 : 1
LOOKING AT PLACARD BRACKET







BUMPER INSTALLATION

SCALE 1 : 1

4	CR3213-4-02	CHERRY RIVET	ALT: HR3213-4-02
8	CR3523-5-02	CHERRY RIVET	ALT: HR3523-5-02
A/R	CR3213-5-02	CHERRY RIVET	ALT: HR3213-5-02
B	NAST149F0683P	WASHER	ALT: ANCREA 40688-14
4	98710-01	FITTING	ALT: ANCREA 40688-14
4	49205-14	BUMPER	ARQUIS INDUSTRIES
1	76627-01	PLACARD	
1	84235-01	06 HANDLE BAR INSTALLATION	
1	MS2000IP4	05 PIANO HINGE	90 INCHES
1	84240-01	04 BRACE INSTALLATION	
1	60632-01	03 LID ASSEMBLY	
1	76611-01	02 BASKET BODY ASSEMBLY	
1	76610-01	01 CARGO BASKET ASSEMBLY	

QTY. PART NO. ITEM DESCRIPTION MATERIAL

LIST OF MATERIALS

LIST OF MATERIALS		APPROVALS		DATE	
BASIC CODE REF. NAS 523		DRAWN: JEFF CLARKE		25 SEPT 2007	
DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE		CHECKED: E. BURGOIN		27 SEPT 2007	
C=COUNTERSUNK D=DIMPLE DIGIT=g OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		 AERO DESIGN LTD. 9886 MALAPASORA ROAD POWELL, HELIX, BC, CANADA, V8A 0G3 TEL: 604.648.5878 www.aerodesign.co	
BASIC CODES: BU=MS20470AD BB=MS20426AD ARN=CR3213 ATM=CR3523		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
+  INSTALL NEW RIVET		DECIMALS ANGLES			
+  REMOVE/REPLACE RIVET		X.XXX ±0.010 ±1/2°			
-  EXISTING RIVET		X.XX ±0.03		BELL 407, 206L SERIES	
		X.X ±0.1		QUICK RELEASE HIGH MOUNTED CARGO BASKET CARGO BASKET ASSEMBLY	
				SCALE 1 : 4	
				DWG. SCALE DWG. NO. REV.	
				SHEET 1 OF 1	
				A1 76610 1	

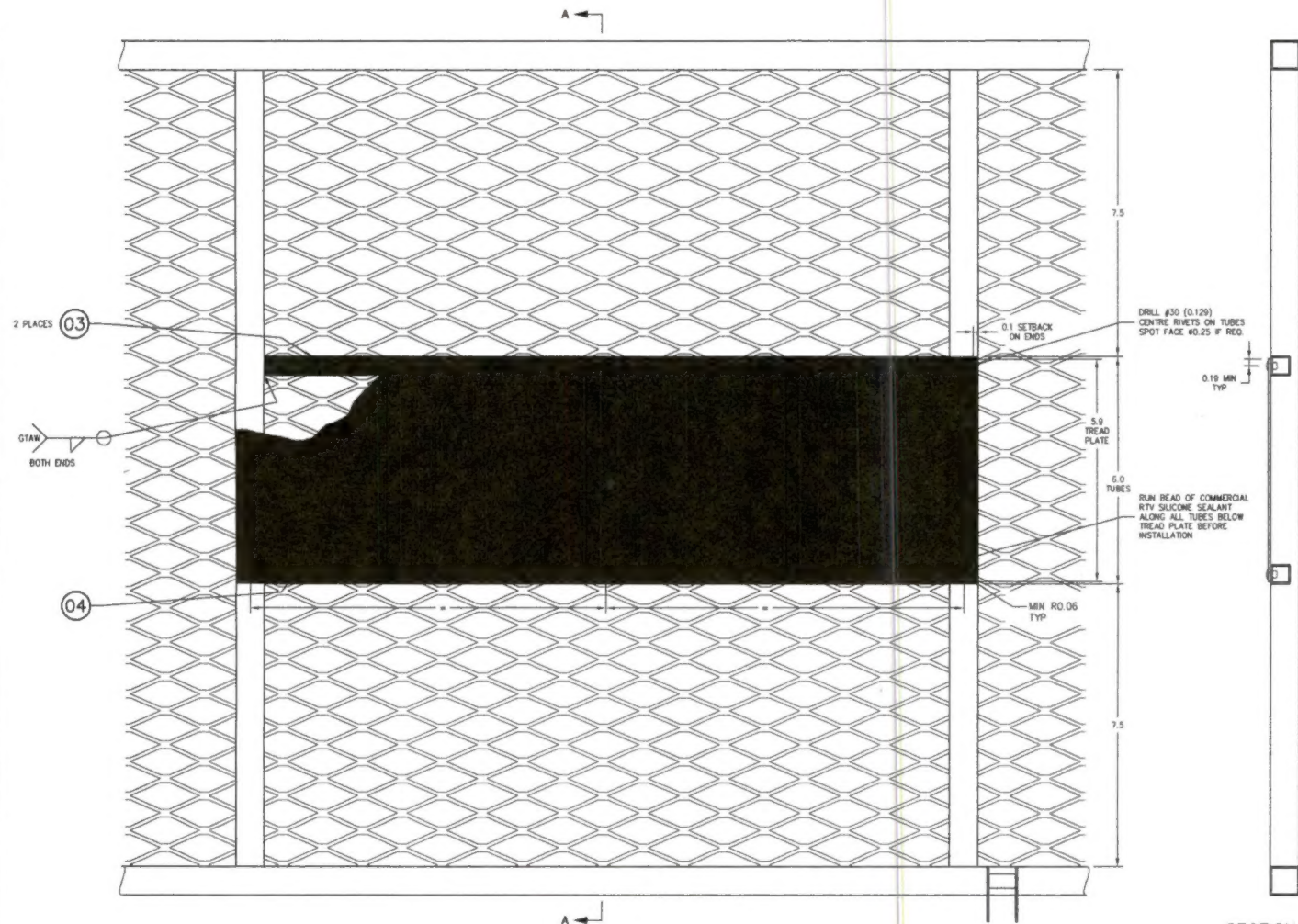


AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.683.2276 www.aerodesign.ca

BELL 407, 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
CARGO BASKET ASSEMBLY

SCALE 1 : 4	DWG. NO.	REV
SHEET 1 OF 1	A1 76610	1



(01) BASKET LID ASSEMBLY

SECTION A-A


THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCCONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TYPE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	28/05/2014

NOTES:

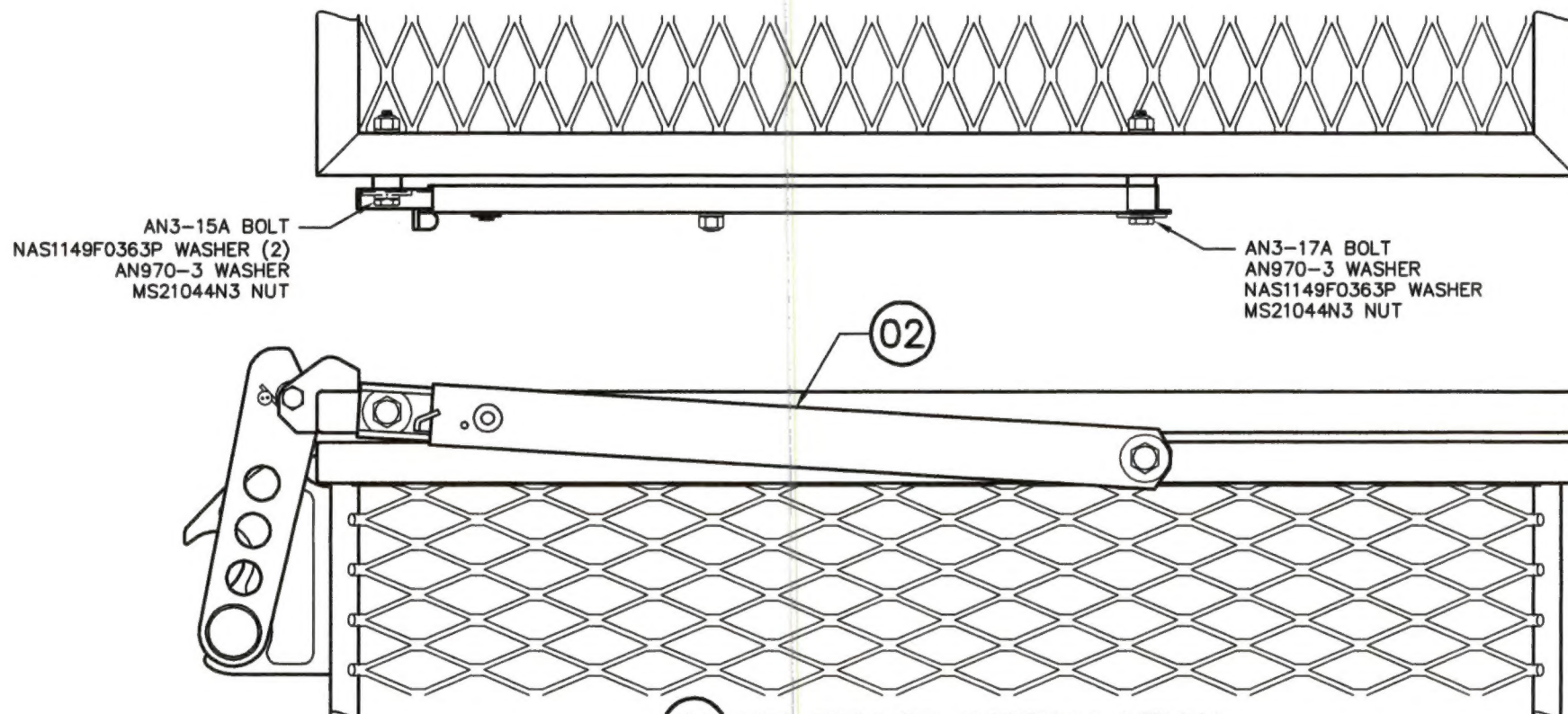
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY ON ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL		
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-6736		
1	SEE NOTE 1	02 BASKET LID ASSEMBLY		0.5 X 0.035 WALL TUBE		
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						

BASIC CODE REF. HAS 523 C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED BASIC CODES: BJ=MS20470AD BB=MS20426AD AR=CR3213 ARN=CR3212	DASH NO. FOR DIAMETER N=MFD. HEAD REAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURGOIN	DATE 21 SEPT 2008	 AERO DESIGN LTD. 8085A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.485.9276 www.aerodesign.ca
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS: X.XXX ±0.010 X.XX ±0.03 X.X ±0.1 ANGLES: ±1/2°		
CARGO BASKET LID STEP MODIFICATION			Dwg. No. 70405	REV. 4

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



(01) LID BRACE INSTALLATION

NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1

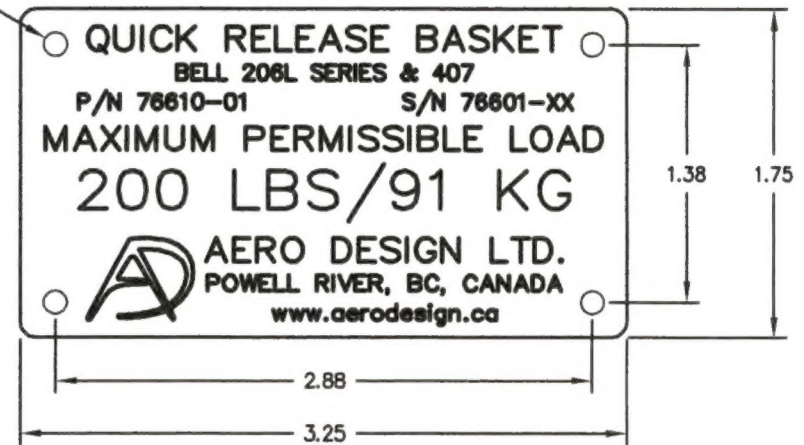
 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.488.2376 www.aerodesign.ca		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION	
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - 76625		
1	DWG # CHANGED TO 76627; UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO	BJC	09/08/2016
	MAT'L THICKNESS CHANGED; P/N ADDED		


NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 206L SERIES & 407" - 0.080 HIGH
 "P/N 76610-01 S/N 76601-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "200 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH
 "www.aerodesign.ca" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

1	76627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.05 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECEPT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS		DATE	 <div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2378 www.aerodesign.ca</div>		
	DRAWN: JEFF CLARKE		09 AUG 2016			
	CHECKED: JASON REKVE		09 AUG 2016			
	UNLESS OTHERWISE SPECIFIED		SPECIFIED	BELL 206L SERIES AND 407 QUICK RELEASE HIGH MOUNTED CARGO BASKET PLACARD		
	DIMENSIONS ARE IN INCHES.		ON:			
	TOLERANCES		ANGLES			
DECIMALS		±1/2°				
X.XXX ±0.010			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
X.XX ±0.03			SHEET 1 OF 1	A1	76627	1
X.X ±0.1						